



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

012513

D350-567-145
Job Sheet 201802



Part No: D350-567-145

Job Qty: 1 pcs

Part Name: Floor Window Close Out (AS350 B3e)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/11/19

Job Tracking No:

Due Date: 10/23/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DSI9590 REV.G IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs		10/23/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S224479



Part: D350-567-145

Job No: 201802

Serial No/Batch: S224479

Revision: G

Inspector:

Exp Date:

Instructions: TC STC SH92-18 Issue 6 FAA STC SH989NE

Plex 10/11/19 9:23 AM Dart.lajeunesse.marie

10/11/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 1 - 32		
				Packaging 1 - 33		
				Packaging 1 - 34		
				Packaging 1 - 35		
				Packaging 1 - 36		
120 QC 4	1 pcs	10/23/19	0.00 0.00	QC 4 - 28		
				QC 4 - 58		
				QC 4 - 69		
				QC 4 - 9		
				QC 4 - 46		
				QC 4 - 68		
				QC 4 - 72		
				QC 4 - 74		
				QC 4 - 75		
				QC 4 - 78		
130 Packaging 3-1 - Stock - B4B 1 pcs		10/23/19	0.00 0.00	Packaging 3 - 1 - B4B	DAS 78 9-89	OCT 2 1 2019
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B	DAS 78 9-89	OCT 2 1 2019
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
135 DC - 1 - B4B	1 pcs	10/23/19	0.00 0.00	DC - 1 - B4B	DAS 21 9-89	OCT 2 1 2019
				DC - 2 - B4B		
140 QC 21 - FG	1 pcs	10/23/19	0.00 0.00	QC 21 - FG - 21	DAS 21 9-89	OCT 2 1 2019
				QC 21 - FG - 70		
				QC 21 - SA - 53		
Part Op 110 - Pick Kit Descriptions: 120 - QC4- 100% inspect kits for completeness 130 - Identify and pack for shipping as per PPP D350-567-145 Location:FG033						

DAS

78

9-89

OCT 2 1 2019

DAS

78

9-89

OCT 2 1 2019

DAS

21

9-89

OCT 2 1 2019

DAS

21

9-89

OCT 2 1 2019

Plex 10/11/19 9:23 AM Dart.lajeunesse.marie

135 - Document Control - Photocopy bluefile & type labels per PPP D350-567-145 CHG001

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A	Bolt	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5192148
AN525-10R6	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5149142
AN525-832R7	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5158306
CB200	Acrylic Adhesive, 3.5G	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5192389
D3802-1	Window Seal (\$ Per Foot)	2 ft (2 ea)	110-Packaging 1 - Pick Kit	5171983
D4435-9	Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5212414
D4436-041	Aft Bracket Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5219769
D4441-1	Rubber Seal	2 ft (2 ea)	110-Packaging 1 - Pick Kit	5092167
D4730-020-030	Velcro Strip 2.0W/ X 3.0L	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5198071
D4971-041	T/R Bellcrank Cover Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5204510
D5076-041	Fwd Bracket Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5156136
MS21042L06	Nut	7 Ea (7 ea)	110-Packaging 1 - Pick Kit	5218601
MS21042L08	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5205000
MS21042L3	Nut	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5211533
MS21059L3	Nut Plate	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5218168
MS35206-229	Screw	7 Ea (7 ea)	110-Packaging 1 - Pick Kit	5143702
NAS1149F0332P	Washer (AN960-10L)	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5207709
NAS1149FN616P	Washer (AN960-6L)	14 Ea (14 ea)	110-Packaging 1 - Pick Kit	5089462
NAS1149FN816P	Washer (AN960-8L)	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	F117316-25

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3-3A	5	214	0
	AN525-10R6	2	267	0
	AN525-832R7	2	91	0
	CB200	1	6	0
	D3802-1	2	34	0
	D4435-9	2	33	0
	D4436-041	1	4	0
	D4441-1	2	257	0
	D4730-020-030	1	8	0
	D4971-041	1	5	0
	D5076-041	1	3	0
	MS21042L06	7	399	0
	MS21042L08	2	1,041	0
	MS21042L3	5	2,971	0
	MS21059L3	2	211	0
	MS35206-229	7	81	0
	NAS1149F0332P	10	2,848	0
	NAS1149FN616P	14	443	0
	NAS1149FN816P	2	169	0

Part Specifications

Specifications could not be found.

Plex 10/11/19 9:23 AM Dart.lajeunesse.marie



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐
Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: _____

Change Record

PAGE 1 OF 1

Part Number: D350-567-145

Description: FLOOR WINDOW CLOSEOUT (AS350 B3e)

[illegible]

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	